










Date: Thursday, 07/08/2008 4:23:24 PM
User: Julie Lecocq

Process Sheet

SPLIT - X3

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 41068 - 3	Part Number	: D3560043
Estimate Number	: 12883	Drawing Number	: D3560 REV D
P.O. Number	:	Project Number	: N/A
This Issue	: 07/08/2008 S.O. No. :	Drawing Revision	: D
Prsht Rev.	: NC	Material	:
First Issue	: 11 Type : MACHINED PARTS	Due Date	: 26/08/2008
Previous Run	: 40300	Qty:	10 Um: Each
Written By	:		
Checked & Approved By	: JLP 08.8.08		
Comment	: Est Rev:A New Issue 07.05.24 EC Est Rev B ECN 987 07.10.09 EC Est Rev:C ECN1048 07-12-18 DD verified by: EC		
Additional Product			
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B0500X05000	6061-T6 Bar .500 x 5.00	
			
Comment:	Qty.: 1.3598 f(s)/Unit Total: 13.5975 f(s) 6061-T6 Bar 0.50" x 5.00" Batch: W/08854		
2.0	BAND SAW	BAND SAW	
			
Comment:	BAND SAW Cut blanks 15.500" long		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
			
Comment:	HAAS CNC VERTICAL MACHINING #1 1- Mill as per Folio FA695 Rev: AA & Dwg D3560 Rev: D 2-C'sink 0.196" hole on manual mill as per dwg D3560 3-Deburr per dwg D3560		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment:	INSPECT PARTS AS THEY COME OFF MACHINE		

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Drawing Name: ARM

Job Number: 41068

Part Number: D3560043

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SD 06/09/02 (42)

6.0 D35921 Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

PLATE

342417=2

344066=5

JK 09.01.14 7

7.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

STEP:

- 1- clean material (buff bracket and bottom of arm with blue pad)
- 2- set up bracket and arm on jig
- 3- preheat bracket and arm with torch
- 4- clean before welding with brush
- 5- set up machine to 135 amps
- 6- weld across bottom and top ends
- 7- reheat with torch (65 deg C)
- 8- on one side weld from bottom to top half way
- 9- same for other side (half way)
- 10- from half way point weld the rest of the first side (ease off pedal near end)
- 11- same for remaining side (ease off pedal near end)

JK 09.01.14 7

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SO 02.06.14 (47)

9.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

BE 09-01-14 (7)

10.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JK 09.01.14 7

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Drawing Name: ARM

Job Number: 41068

Part Number: D3560043

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

5 02/01/14 (x7)

12.0

D2808

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
Spacer
batch: B35330

*

09/01/14

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1-Press bushing in D3560 arm per dwg D3562

09/01/14 (7)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 02/01/15 (17)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: Steve (Moffin)

09/01/15 (1A)

16.0

QC21

FINAL INSPECTION/W/O RELEASE



09/01/15

Comment: FINAL INSPECTION/W/O RELEASE

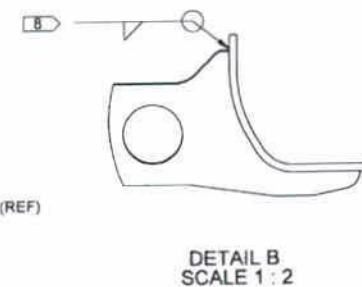
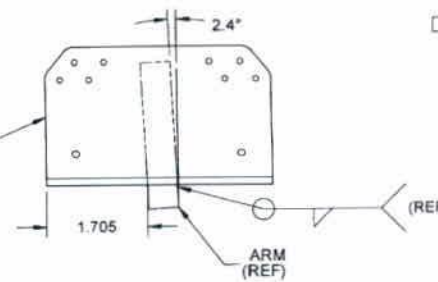
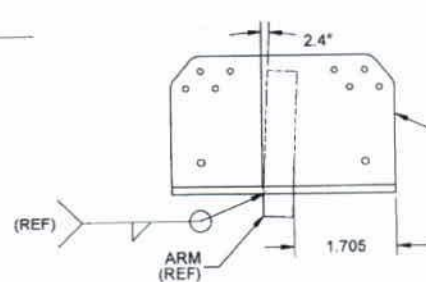
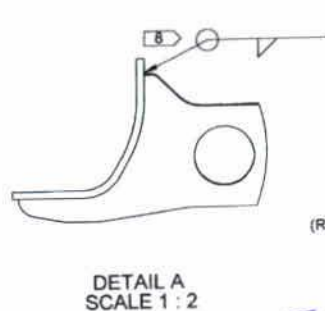
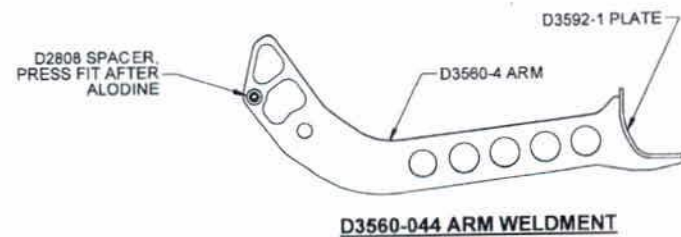
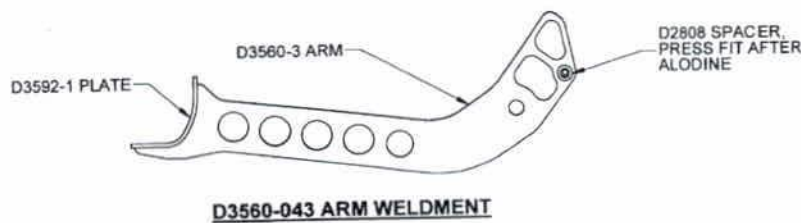
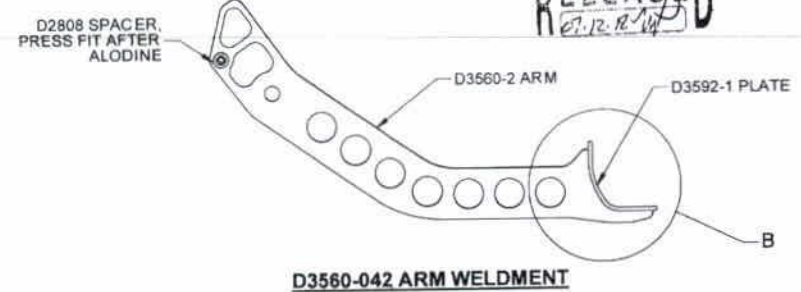
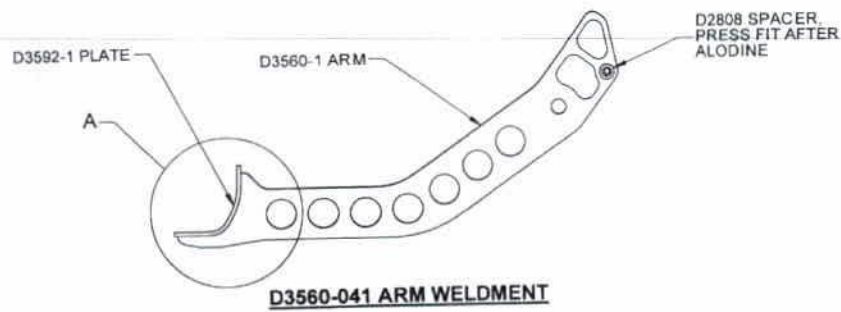
Job Completion



09.06.15

REFERENCE ONLY

RELEASED
07.12.16



PARTS LIST

QTY -041	QTY -042	QTY -043	QTY -044	P/N	DESCRIPTION
X				D3560-041	ARM WELDMENT
	X			D3560-042	ARM WELDMENT
		X		D3560-043	ARM WELDMENT
			X	D3560-044	ARM WELDMENT
1	1	1	1	D2808	SPACER
1				D3560-1	ARM
	1			D3560-2	ARM
		1		D3560-3	ARM
			1	D3560-4	ARM
1	1	1	1	D3592-1	PLATE

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.23 lbs (TYP)
- 8) WELDING: PER DART QSI 004

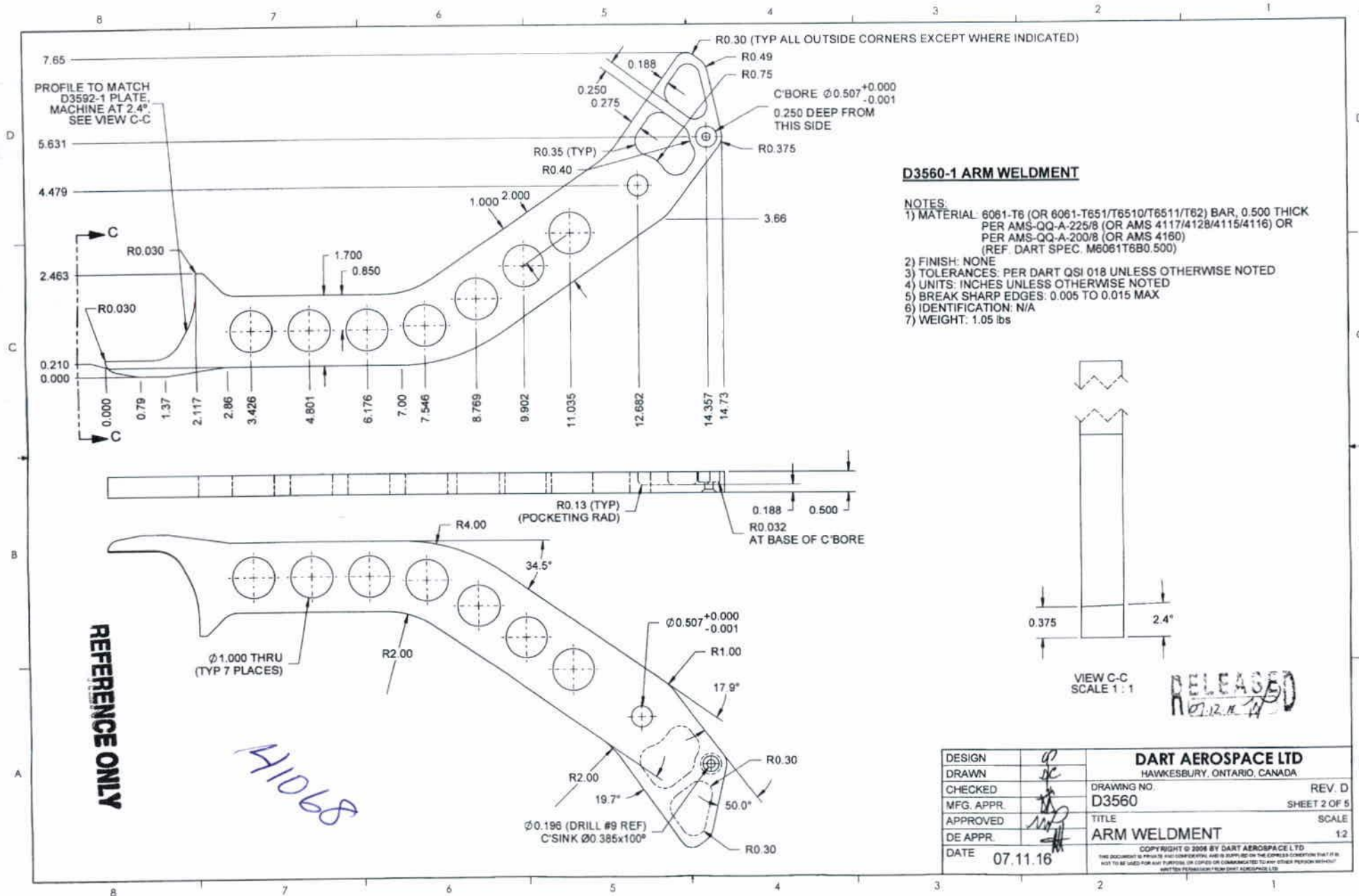
DESIGN	ADD D2808 PRESS FIT NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
DRAWN	REMOVE POWDER COAT	CP	07.08.19
CHECKED	REDESIGN AS WELDMENT, ADD POCKETS	CP	07.01.15
MFG APPR.	NEW ISSUE	CP	06.09.25
APPROVED		BY	DATE
DE APPR.			
DATE	07.11.16		

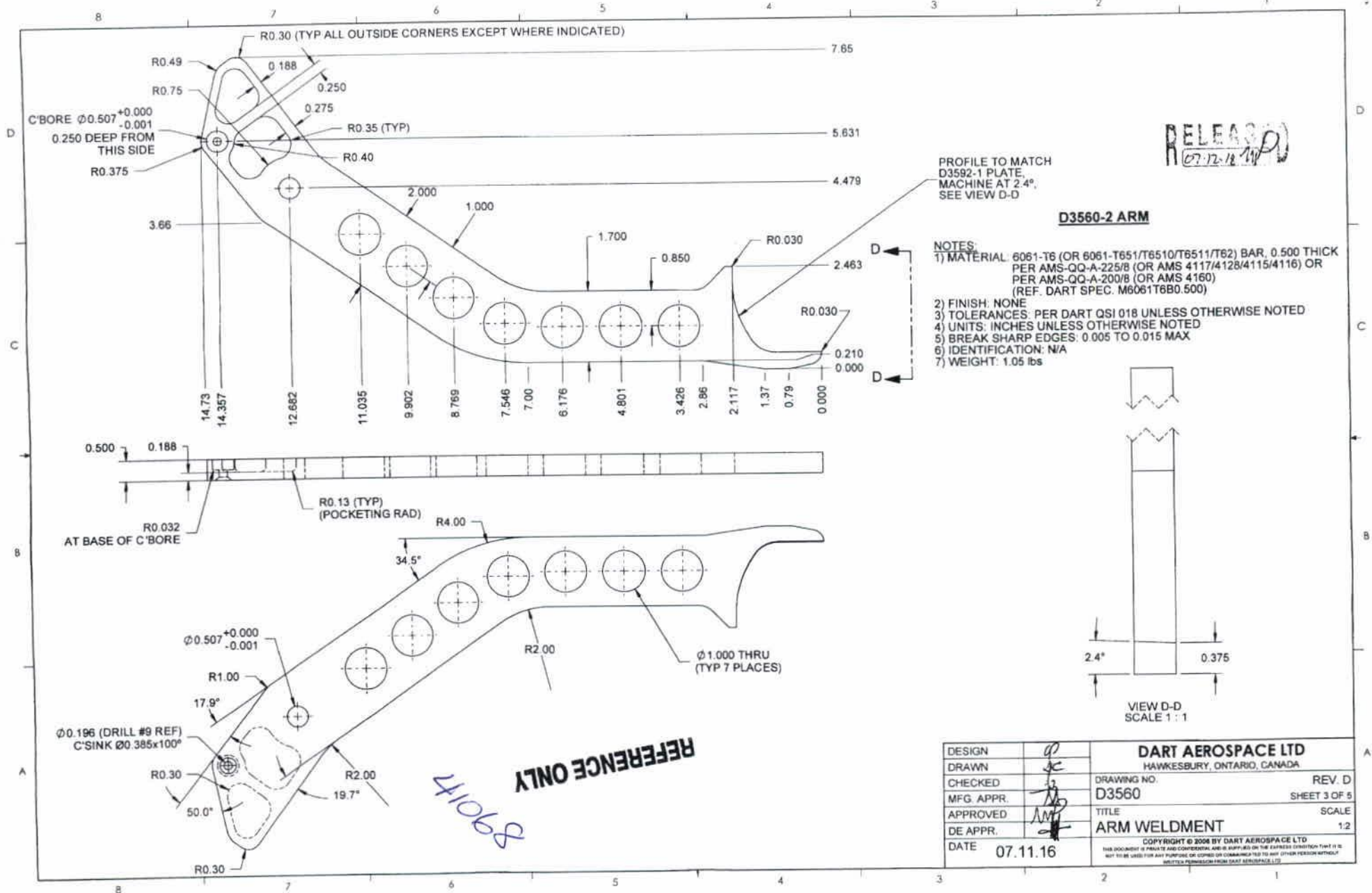
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3560	REV. D
TITLE ARM WELDMENT	SHEET 1 OF 5
SCALE 1:4	

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41068

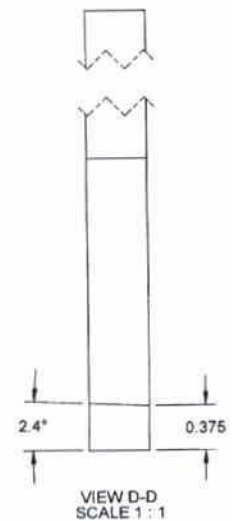




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07-12-14

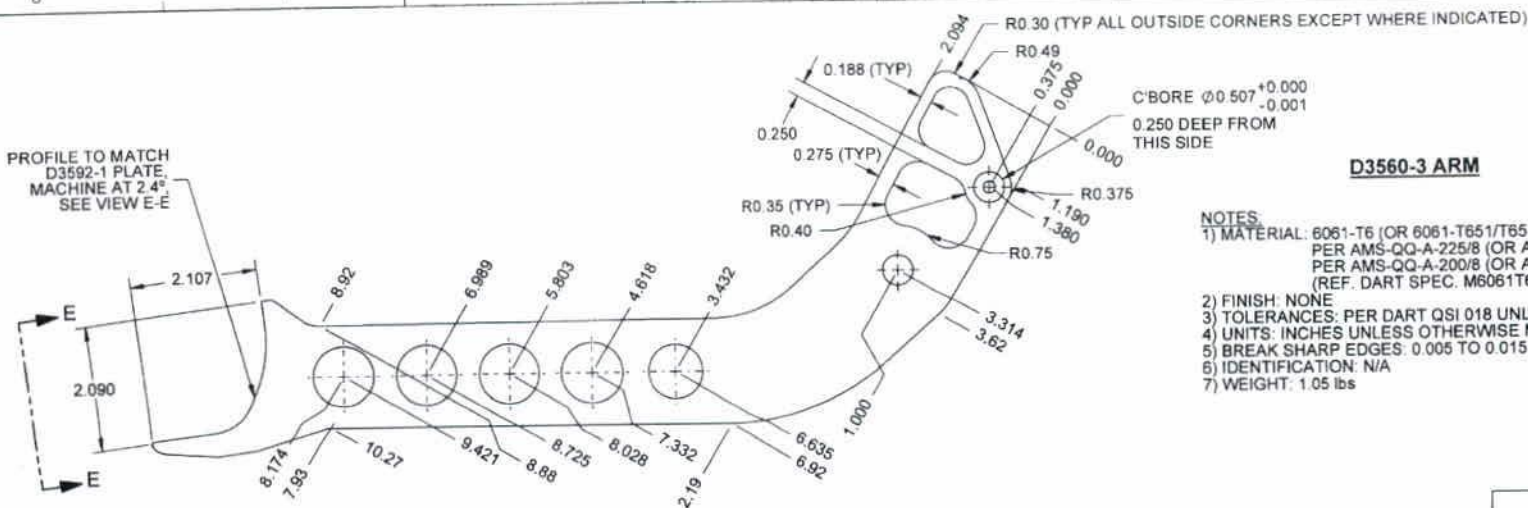
D3560-2 ARM

- NOTES:**
 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6B0.500)
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 1.05 lbs



DESIGN	89017	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JK	DRAWING NO. D3560	REV. D SHEET 3 OF 5
CHECKED	JK	TITLE ARM WELDMENT	SCALE 1:2
MFG. APPR.	LM	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. NO REPRODUCTION OR DISSEMINATION OF THIS DOCUMENT IS TO BE MADE FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
APPROVED	LM	DATE 07.11.16	
DE APPR.	LM		

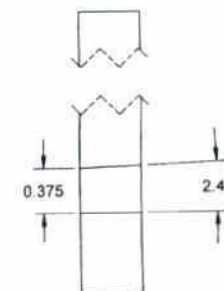
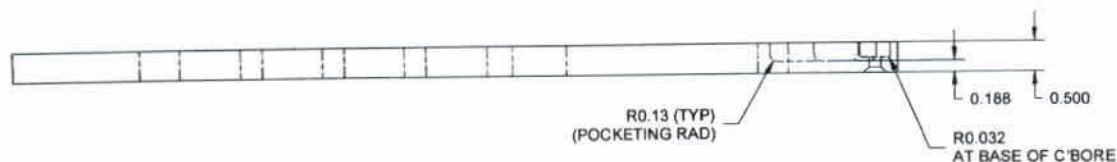
PROFILE TO MATCH
D3592-1 PLATE
MACHINE AT 2.4°
SEE VIEW E-E



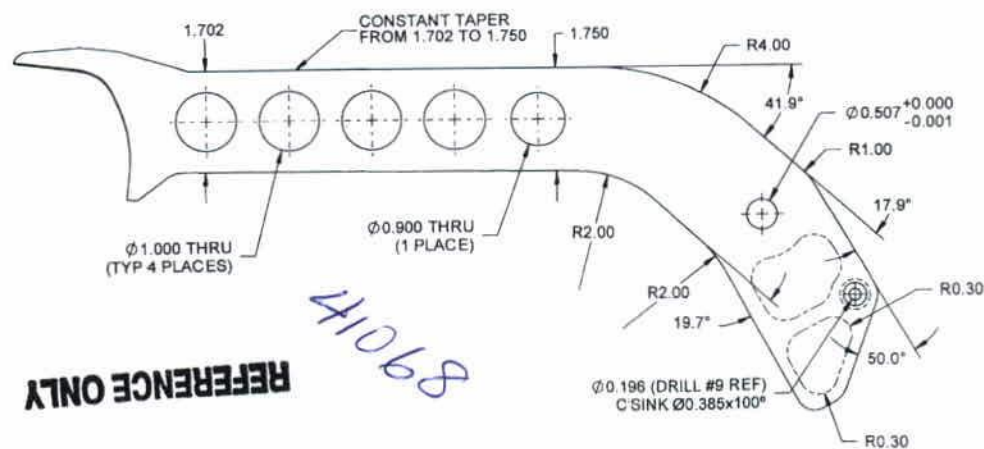
D3560-3 ARM

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs



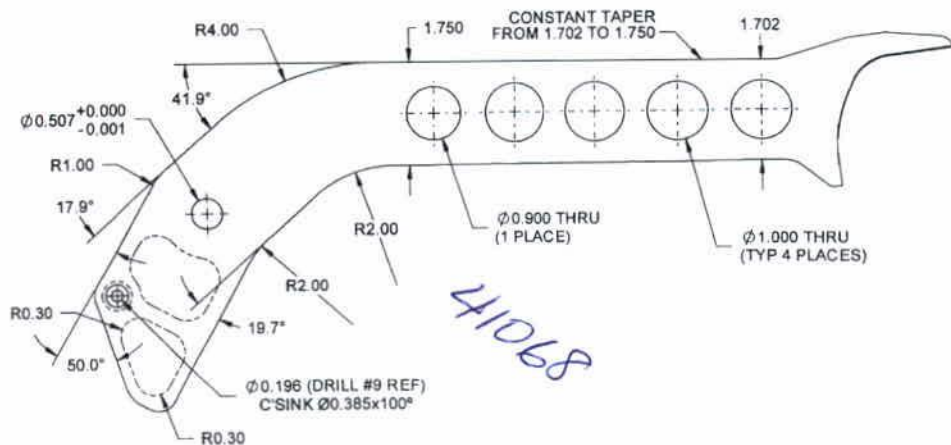
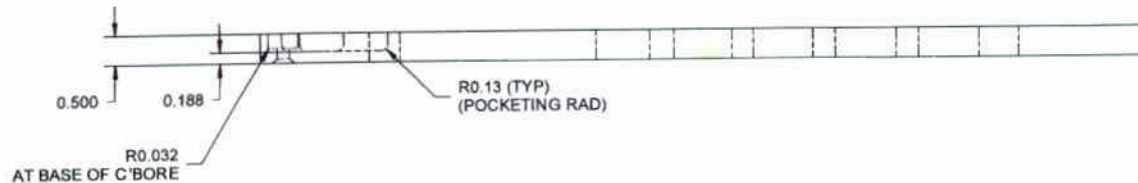
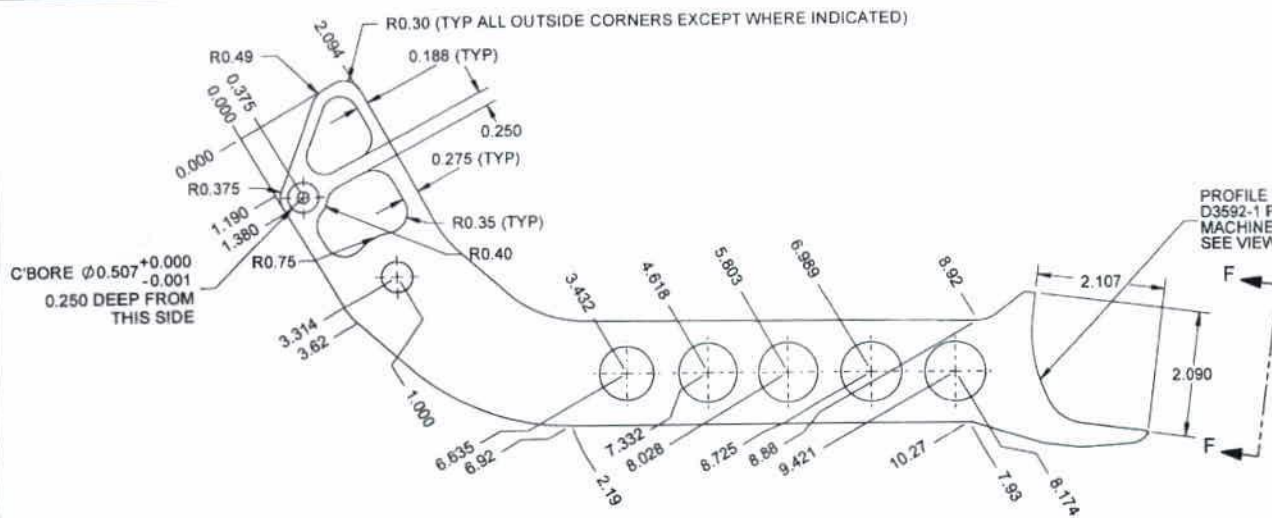
VIEW E-E
SCALE 1:1



REFERENCE ONLY

89014

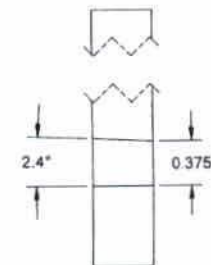
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DRAWN	4C		
CHECKED	4C	DRAWING NO. D3560	REV. D SHEET 4 OF 5
MFG. APPR.	4C	TITLE ARM WELDMENT	SCALE 1:2
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DE APPR.	4C		
DATE	07.11.16		



D3560-4 ARM

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs



VIEW F-F
SCALE 1:1

DESIGN	JP	DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. D
MFG. APPR.	JP	D3560	SHEET 5 OF 5
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	ARM WELDMENT	1:2
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